

Process Sheet

Form: mroccss

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:09:32 AM
User: Kim, Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36055

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143
Inside of Cuff(Donot engrave on outside of tube)

J.F. 07/12/10 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/10 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SR 07.12.11 ①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AW 07-12-11

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-12-11

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SR 7-12-11

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

EL 7-12-11

W/O:		WORK ORDER CHANGES					
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Drawing Name: 206L FWD X-TUBE

Job Number: 36055

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



7-12-11 (1)



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

SR

7-12-12

AWM 07-12-12

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 07-12-12

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/12/13 (14)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/12/13 (14)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 206L FWD X-TUBE

Job Number: 36055

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5299 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

CD 7/12/170

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

LC 7/12/170

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

LC 7/12/170

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

KE 07-12-170

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

Jan 00

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total: 1.2138 f(s) (Cut to 4")

Pick:

Qty Part number Description Batch

2 D2856-400 (Cut to 6 3/4") Abrasion Strip 25656

ml 07 12 18

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 33422 / 34061

mini 2008/1/3
25 07 12 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 28/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/19	20.0	Appears that someone touched paint in middle section of tube while it was wet.	<i>[Signature]</i> QSI 005	Sand and repaint mid section of X-tube with white iron as per QSI 005	<i>[Signature]</i> 07-12-19	<i>[Signature]</i> 07-12-19	<i>[Signature]</i> QSI 005	<i>[Signature]</i> 07/12/19

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:09:32 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36055

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

34077

25 07-12-15

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

34062

ml 07 12 18

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

105057

25 07-12-15

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

103478

ml 07 12 18

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

25 07-12-15

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36055

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

QC5

INSPECT WORK TO CURRENT STEP



11-12-31



Comment: INSPECT WORK TO CURRENT STEP

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: *M105408*

SP

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: *M1059410*

SP

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

10 AN5-7A

Description Batch

Bolt

M104374

M106168

SP

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt

M103611

SP

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

18 AN960JD516

Description Batch

Washer

M104156

8/01/02

SP (12)

W/O:		WORK ORDER CHANGES					
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Date: Thursday, 11/29/2007 11:09:32 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36055

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/02 (71)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: 3

PPP Rev: 8/1/02

FINAL INSPECTION/W/O RELEASE

38.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

08/01/03 (1)

Job Completion



2005/1/3
u

36055 206 667 103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 36055
Description: Crosstube Assembly (206L High Fwd)	Part Number: D206-667-143
Inspection Dwg: D206-667-143 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

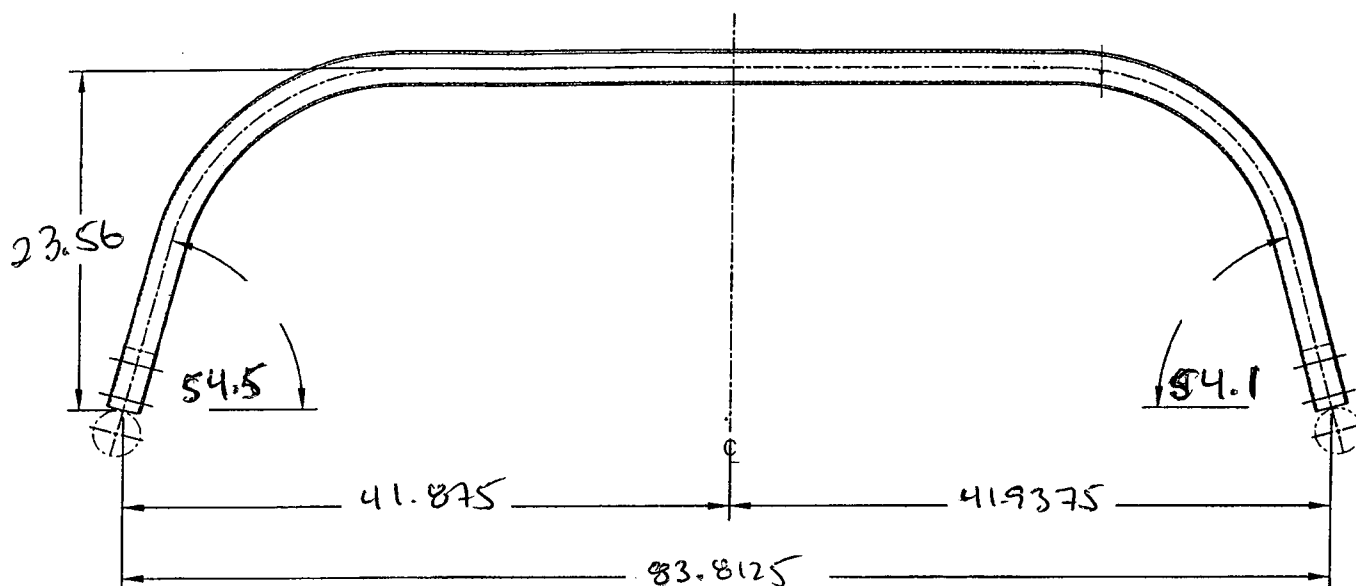
Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244"	✓			
	1.982	+0.005/-0.000	2.187"	✓			
	2.019	+0.005/-0.000	2.024"	✓			
	2.058	+0.005/-0.000	2.063"	✓			
	2.097	+0.005/-0.000	2.101"	✓			
	2.136	+0.005/-0.000	2.138"	✓			
	2.176	+0.005/-0.000	2.180"	✓			
	2.201	+0.005/-0.000	2.205"	✓			
	0.125	+/-0.010	.125	✓			
	0.400 x 30°	+/-0.010	.400 x 30°	✓			
	R0.063	+/-0.010	R0.063"	✓			
	R0.500	+/-0.010	R0.500"	✓			
	4.438	+/-0.030	4.445"	✓			
SIDE B	104.98	+/-0.020	104.96	✓			
	2.240	+0.005/-0.000	2.243"	✓			
	1.982	+0.005/-0.000	1.987"	✓			
	2.019	+0.005/-0.000	2.024"	✓			
	2.058	+0.005/-0.000	2.163"	✓			
	2.097	+0.005/-0.000	2.101"	✓			
	2.136	+0.005/-0.000	2.138"	✓			
	2.176	+0.005/-0.000	2.189"	✓			
	2.201	+0.005/-0.000	2.203"	✓			
	0.125	+/-0.010	.125	✓			
	0.400 x 30°	+/-0.010	.400 x 30°	✓			
	R0.063	+/-0.010	R0.063"	✓			
	R0.500	+/-0.010	R0.500"	✓			
	4.438	+/-0.030	4.445"	✓			

Measured by: JF/J.F.	Audited by: SA	Prototype Approval: N/A
Date: 07/12/09	Date: 01.12.11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

DART AEROSPACE LTD		Work Order:	36055
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
height is slightly un-even by 0.030" but within tolerance

QC15 Inspection	
Date	07.12.11

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26

UNDER REVIEW

05-08-10 PH
re-draw detail F
PH

07.05.02

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

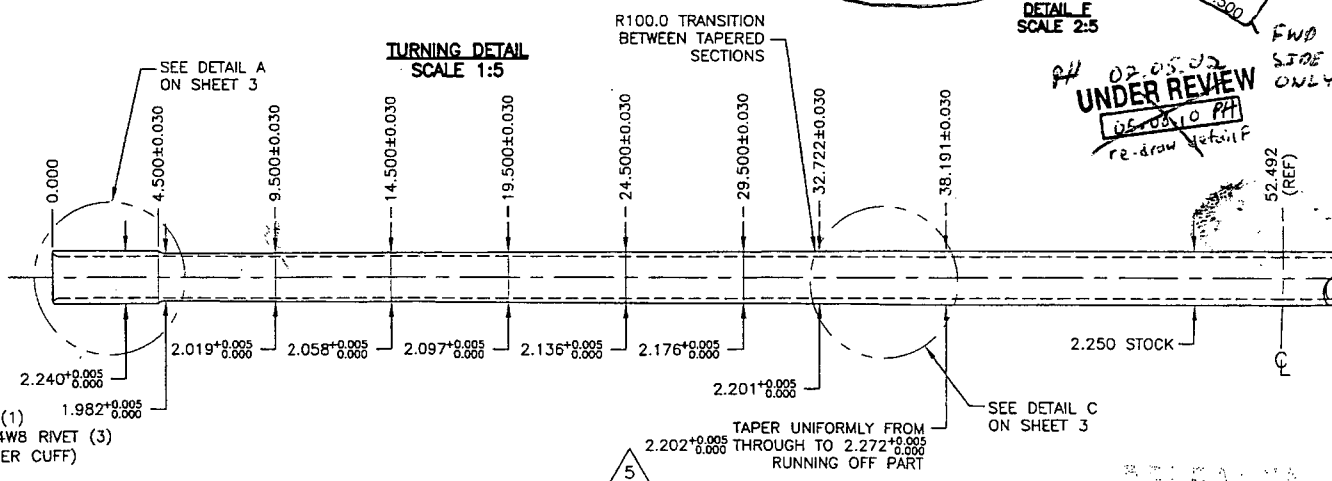
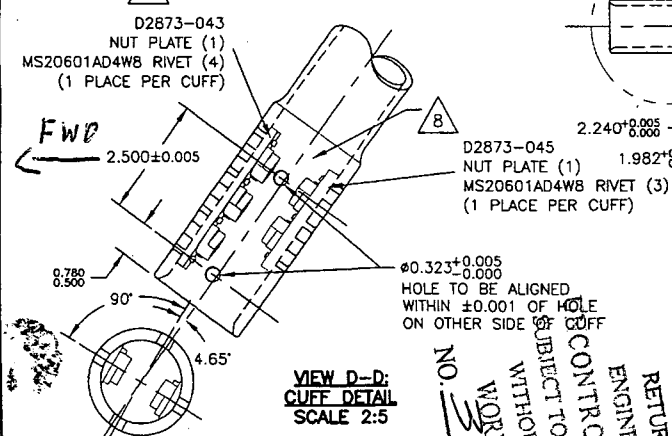
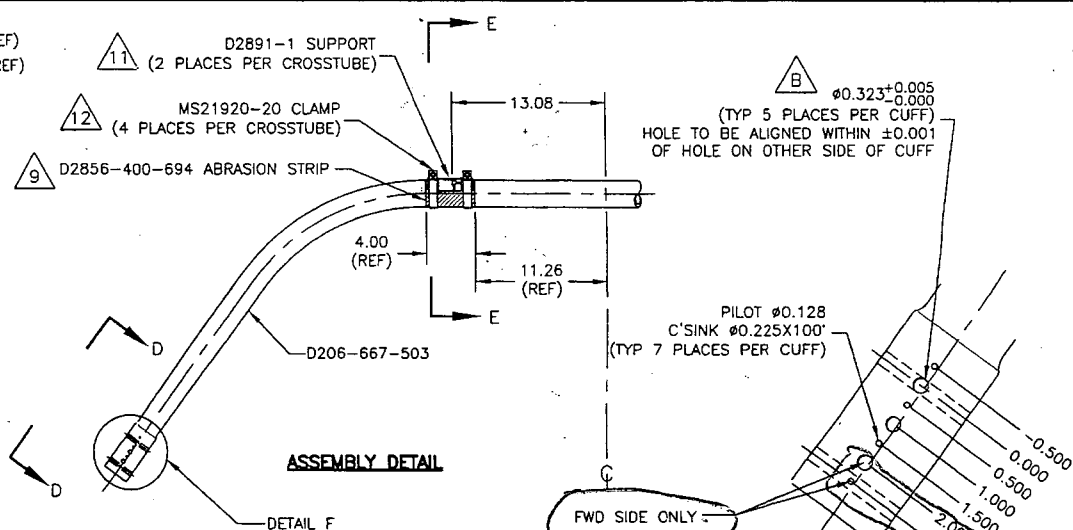
GENERAL NOTES:


- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

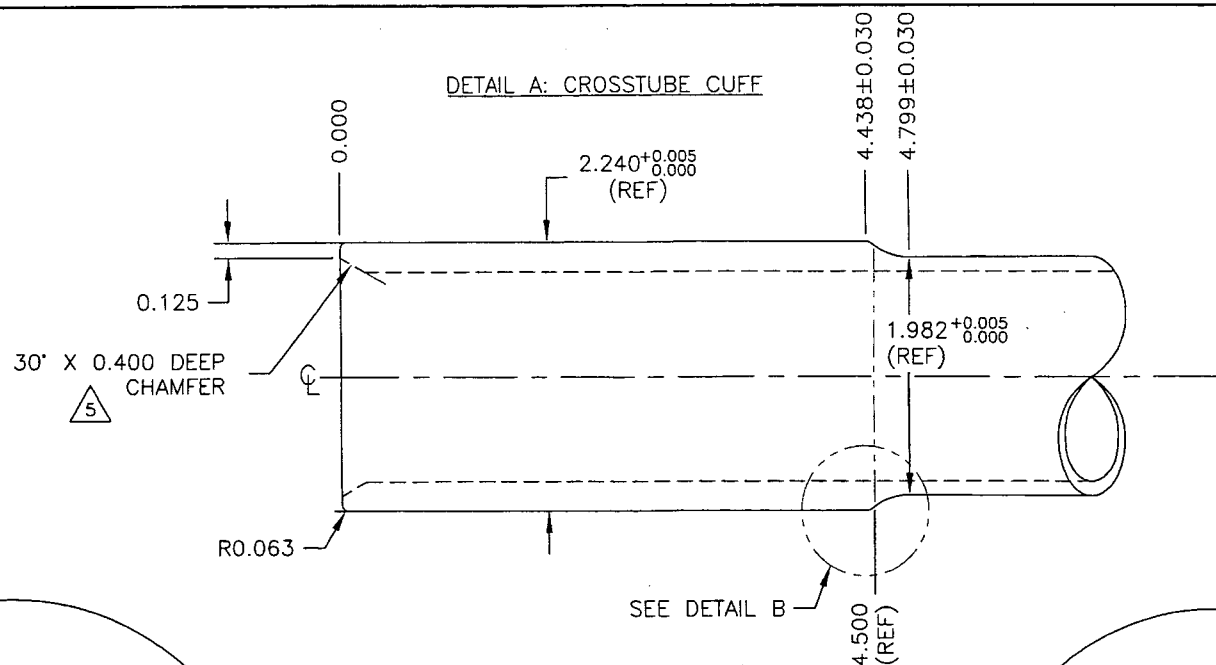
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36055

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DESIGN	DRAWN BY		DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
PH	PH		
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE 1:10

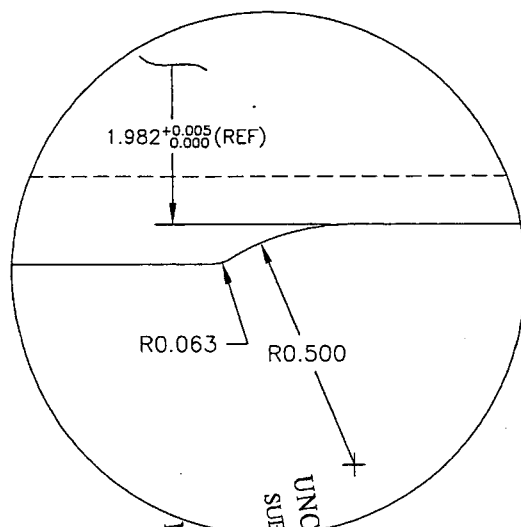


05.07.26 #

UNDER REVIEW

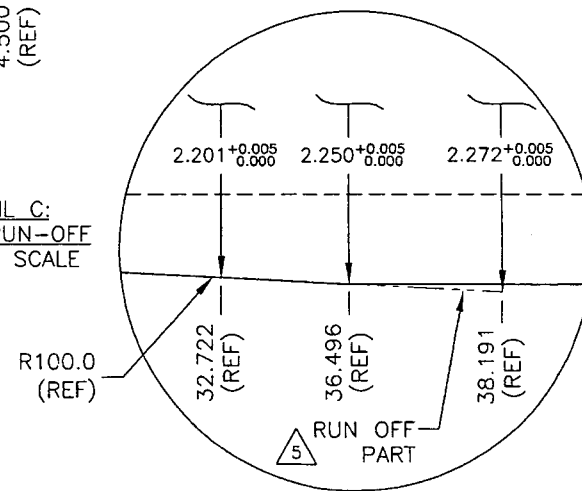
06.08.02 PH

PH 07.05.02



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 36055

WORK ORDER

SUBJECT TO AMENDMENT

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		PH	PH	DRAWING NO. D206-667-143	REV. B SHEET 3 OF 3
CHECKED HDS		APPROVED HDS		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE 1:1
DATE 05.07.26					



LIQUID PENETRANT TEST REPORT

P - 7-1055

CLIENT DART AREOSPACE DATE DEC. 14, 2007 PAGE 1 OF 1
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-7-01055 TIME AM ☐ PM ☐
ADDRESS 1270 ABERDEEN ST. HAWKESBURY ONT. PO/WO No. P/O 5299
WORK LOCATION HAWKESBURY
ACCEPTANCE STD. ASTM 1417/QSI-038 REV./DATE 2005
PROJECT 212/205 HIGH FED X-TUBE, 206L FWD X-TUBES, 206BAFT X-TUBES, 206L AFT X-TUBES
ITEM(S) EXAMINED JOB #'S 35725, 35893, 36051, 36053, 36055, 36056, 36057, 36059,

JOB DESCRIPTION PROCEDURE No. LT-0002 REV./DATE TECHNIQUE No. LT-0002-02 REV./DATE
Part No. D206667201, D206667203, D212664101, D206667103 Material ALODYNED ALUMINUM Thickness
Scope WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.

TEST DETAILS

Method ☒ Fluorescent ☐ Visible ☒ Water Wash ☐ Solvent Removable ☐ Post Emulsified
Family Brand MAGNAFLUX Black Light S/N 8178 ☒ Output > 1000 μ W/cm² ☒ Ambient < 2 fc
Penetrant ZL67 Minimum Dwell time 45 Min. Lighting Equip. ☒ Flashlight ☐ Troublelight ☒ Output > 100 fc @ surface
Penetrant Remover H2O Minimum Dry time >10 Min. Other
Developer SKDS2 Minimum Dwell time 10 Min. Light Meter S/N Cal Due Date MAR 08
Developer Type ☒ Non Aqueous ☐ Aqueous ☐ Dry

TEST SURFACE

Surface Condition ☒ As Ground ☐ As Welded ☒ Machined ☐ Shot Blasted ☐ Clean Bare Metal
Surface Temperature ☐ < - 4°C/ 20°F ☐ - 4°C/ 20°F to 10°C/50°F ☒ 10°C/50°F to 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

item Comments Accept Reject

F.L.P.I. CARRIED OUT ON 100% OF
EXTERNAL SURFACE OF: 212/205 HIGH
FED X-TUBES JOB# 35893
206B AFT X-TUBES JOB #'S 36051, 35725
206L FWD X-TUBES JOB#'S 36053, 36055
206L AFT X-TUBES JOB #'S 36057, 36059, 36056
RESULTS: 206B AFT X-TUBE #36051 HAS ROUGH
GRINDING MARKS. TO BE POLISHED AND RECHECKED
AT A LATER DATE.
ALL OTHER JOB #'S ARE ACCEPTABLE TO ASTM 1417/
QSI-038 STANDARD.

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

Client Representative DTR #
Technician (Signature): FREDERICK CHAGNON BRENDON MIRAN
Name (Print): FREDERICK CHAGNON BRENDON MIRAN
CGSB Level II SNT Level CGSB Level II SNT Level
CGSB Reg. No. 10560 CGSB Reg. No. 12247

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Date: Thursday, 11/29/2007 11:09:31 AM
 User: Kim Johnston

Process Sheet

52

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L FWD X-TUBE
Job Number : 36055	
Estimate Number : 10553	
P.O. Number :	Part Number : D206667103
This Issue : 11/29/2007 S.O. No. :	Drawing Number : D206-667-143 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : B
Previous Run : 36054	Material :
Written By :	Due Date : 12/24/2007 Qty: 1 Um: Each
Checked & Approved By : <u>11/29/07</u>	
Comment : Est Rev: F05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

07.12.07 JA

2.0	D6002115	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube

Check OD = 2.250"; ID = 1.750"

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

REFERENCE ONLY

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET